



PATENT ABSTRACTS OF JAPAN

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NAKANE YUTAKA**(54) **ARC WELDING METHOD**

(57) Abstract:

PURPOSE: To uniformize a heat input and to enable an uniform bead in case of an arc welding by executing sufficient melting by a high welding voltage just after welding start and setting the welding voltage to a welding level with gradually reducing it according to the progress of welding.

CONSTITUTION: The shortage of heat input by the oxide film existing on the surface of an aluminum and the thermal absorption of a base metal are compensated by applying the welding voltage of the hot start level $V1+V2$ which is higher than the set level at welding time after welding start. According to the welding progress an attenuation change, i.e., a welding voltage level is slow down to $V2$. The attenuation variation time of the welding voltage is regulated as a slow-down time T , which is set in advance by the thickness, size, etc., of the material of the base metal similar to the hot start

level $V1$ and welding voltage level $V2$. The cladding by welding of a bead 7 and the uniform arc welding of widths $W1$ and $W2$ are thus enabled.

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